

Work Order ID 76855

76855

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November-22-11 10:54:53 AM

Item ID: D119-675-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step RH
 Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/11/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP 119-675-012 CHG003								

MLJ 11-12-21 (4)

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

SP 11-12-21

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

W 11-12-22 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-675-012								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SP 11-12-22

11/12/23

MF 11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D119-675-012

Required Date: 06/12/2011

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP Rev:E change to rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3043-042 *D3043-042* Step Weldment RH, A119		Manufactured	No			110	Each	0.0000	1	4			
D2182B032 *D2182B032* Rubber Cushion		Manufactured	No			110	Each	24.0000	4	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402		24							
				63469		4							
				73932		20							
D2274 *D2274* Radius Block		Manufactured	No			110	Each	463.0000	8	32			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		250							
				72121		16							
				73389		234							
				ST139		213							
				74435		213							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76855

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

W *X* *Y* D2617-3
D2617-3
Bushing

Manufactured No

110 Each 26.0000

4 16

**

10x 7694857

Location	Loc Qty	Loc Code
FG	10	
27991	10	
ST019	6	
68254	6	
ST020	10	
76818	10	

6x.

W *X* *Y* D2617-5
D2617-5
Spacer

Manufactured No

110 Each 38.0000

1 8 32

**

B 775029x 8

Location	Loc Qty	Loc Code
FG	10	
31756	10	
ST019	28	
73710	28	

~~7x 3x~~ 23.

W *X* *Y* D2732-032
D2732-032
RUBBER CUSHION

Manufactured No

110 Each 10.0000

1 1 4

**

SP.

Location	Loc Qty	Loc Code
ST	10	
70987	10	

W *X* *Y* D3041-1
D3041-1
Clamp

Manufactured No

110 Each 20.0000

4 16

**

SP 11-12-21

Location	Loc Qty	Loc Code
ST462	20	
67778	20	

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 76855

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

WHL
x4 D3041-3
D3041-3
Clamp

Manufactured No

110 Each

8.0000

1 2
**

8
B76181 SP

Location

Loc Qty

Loc Code

ST462

8

51114

8

110 Each

15.0000

1 4
**

16

WHL
x4 D3042-1
D3042-1
Clamp

Manufactured No

Location

Loc Qty

Loc Code

ST457

15

67402

15

110 Each

248.0000

1 4
**

16

SP 11-12-22.

1XB77487 SP

~~16~~ 15x

WHL
x4 AN4-11A
AN4-11A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST356

248

110382

1

115316

47

117872

100

118706

100

110 Each

178.0000

1 8
**

32

SP 11-12-21.

WHL
x4 AN4-12A
AN4-12A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST357

178

115422

4

117508

74

118628

100

32x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased

No

110

Each

295.0000

4

16

AN4-15A

Bolt

**

M119862 SP
16x.

Location

Loc Qty

Loc Code

ST358

295

118112

4

118648

63

118706

19

119127

9

119449

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

12

48

AN960JD416

Washer

**

M119075 SP

MS21042L4

Purchased

No

110

Each

11,294.00

12

48

MS21042L4

Nut

**

SP 11-12-21.

Location

Loc Qty

Loc Code

ST300

552

117441

51

117601

368

118451

133

ST516

5742

119017

5742

ST518

5000

119075

5000

48x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART AEROSPACE USA, INC.

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32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011 HELI-ACCESS-STEP™, LH	11.5 lb 5.2 kg	- 32.4 in - 1.28 m	- 373 in-lb - 6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg
D119-675-012 HELI-ACCESS-STEP™, RH	11.5 lb 5.2 kg	+32.4 in +1.28 m	+373 in-lb +6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg

32.4 PARTS LIST

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	HELI-ACCESS-STEP™, LH
	X	D119-675-012	HELI-ACCESS-STEP™, RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: 2

32-00-00
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Part Number D119-675-011 / for Change Record
Description A119 HA1 - ACCESS - STEP

Part Number D119-675-011 for 2
Description A119 H21-ACCESS-STEP

Page 1 of 1

Chg.	Date	By	Relevant Documents
001	01.07.05	1	PER MDL-D119-675 REV. A
002	01.09.06	1	CHANGE TO D3040-1/-3 PER D3040 REV. B CHANGE TO D3041-1/-3 PER D3041 REV. A1
003	08.01.10	1	MDL-D119-675 Rev. D ECN 1078
004	09/07/13	1	MDL-D119-675 Rev. E, DEV-D3041-C-1 ECN 09-627